

Wednesday, 1/30/2008 7:57:07 AM
Kim Johnston

Process Sheet

Split 1/0305

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY
Job Number	: 37082-1	Part Number	: D3331041
Estimate Number	: 10439	Drawing Number	: D3331 REV. C
P.O. Number	:	Project Number	: N/A
This Issue	: 1/30/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Due Date	: 2/11/2008
Previous Run	: 35440	Qty:	19 Um: Each
Written By	:		
Checked & Approved By	: <u>HA 080130</u>		
Comment	: Est: C 05.05.26 Added D3158-050 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1025TR0875W125	1025 Round Steel Bar
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Comment: Qty.: 1.5000 f(s)/Unit Total: 30.0000 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall

(M1025TR0.875W.125)

Batch: M107021

J.F. 08/02/11 (20)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut handle to finish length as per Dwg D3331

2- Form as per Dwg D3331 using DT8760 crimping Jig

J.F. / 88 08/02/14 (20x)

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg D3331

Identify as D3331-1

H.A. / 08/02/16

J.F. /

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. /

H.A. / 08/02/16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

H.A. / 08-02-18 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:57:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 37082

Part Number: D3331041

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 238032 3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description	Batch
1	238-032	3/16"-1" long Dowel	M106162

8/08/03/05 (19x)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Deburr

2- Drill dowel hole as per Dwg D3331

3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	M105138

Batch

M106162

8/08/03/05 (19x)

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-05 (19)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M 18052

M-1 08/03/05

(19x)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-05

X 19

11.0 GP78R Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Black Vinyl Grid

Pick:

Qty	Part Number	Description	Batch
1	GP-78R	Black Vinyl Grid	18060 9x

18060 9x

10x

12.0 D3158 Heat Shrink



Comment: Qty.: 0.4166 f(s)/Unit Total: 8.3320 f(s)

Heat Shrink

Pick:

24615

1/4/3/5 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:57:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 37082

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description
5" D3158 Heat Shrink

Batch

B24615

19x

20 08/03/06

19x

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble as per Dwg D3331
Identify as D3331-041

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST494

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



20 08/03/06
L 08/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

